

Work Order ID 58833

Wednesday, May 19, 2010 1:07:59 PM



Page 1

Item ID: D3641-4

Accept



Setup Start



Revision ID:

Item Name: Cover

Stop



Start Date: 5/19/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3641

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

5052-032

1-Cut as per Dwg D3641

Dwg Rev: 5

Prog Rev: 2

2-Deburr if necessary

B 10-6-2

(4)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-6-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 10606103

(x4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3641-4	0.00 0.00	SB 10/06/19			(4)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 06/06/18			(14)			
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	ml 10 06 21						(4)

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Page 3

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Item Name: Cover

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Start Date: 5/19/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control



BR 10-6-21.

170

Identify as per dwg & Stock Location: SD60

0.00

Packaging

Memo

0.00

Packaging

P14/21 (4)

180



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

10/06/23
h 10-26-22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:08:04 PM

Page 1

Work Order ID: 58833



Parent Item: D3641-4



Parent Item Name: Cover

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	67.5000	0.7851	3.2		
5052-H32 .032 Sheet											12-10-6-2	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT23	67.5	
100470	3	
103321	3	
105998	7	
108462	10	
109478	9	
111448	3	
112664	29.5	
15031	3	

112664

W/O:		WORK ORDER CHANGES					
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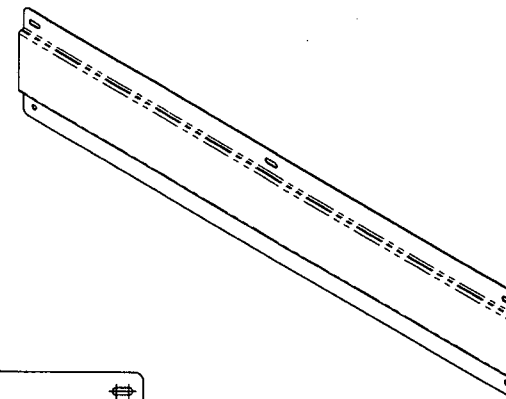
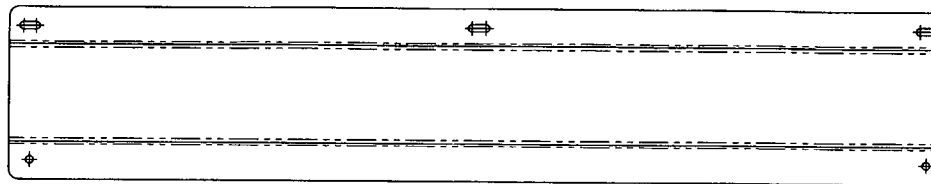
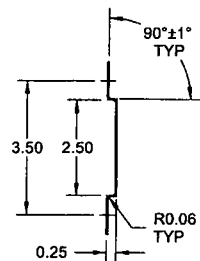
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NOTE: Date & initial all entries



D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)
 (MAKE FROM D3641-1F FLAT PATTERN)

RELEASED
 2009-11-18
WP

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. *58833*

2510-5-19

NOTES:

- 1) MATERIAL: D3641-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

C	REFORMAT DRAWING TO CURRENT STANDARDS; D3641-3 WAS -4 (ZN C4-2); ADD D3641-4 VIEW (ZN A4-2); MOVE -1F/3F FLAT PATTERN TO SHEET 3. PER NCR 09-076	RF	09.10.02
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	RF		
CHECKED	<i>RP</i>		
MFG. APPR.	<i>RP</i>		
APPROVED	<i>RP</i>		
DE APPR.	<i>RP</i>		
DATE	09.10.02		

DART AEROSPACE USA, INC.
 PORT HADLOCK, WA

DRAWING NO.
D3641
 TITLE
COVER
 REV. C
 SHEET 1 OF 3
 SCALE
 NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

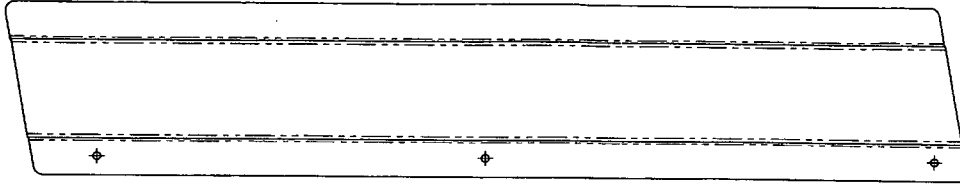
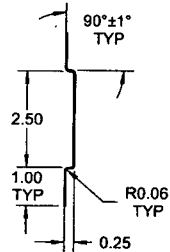
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

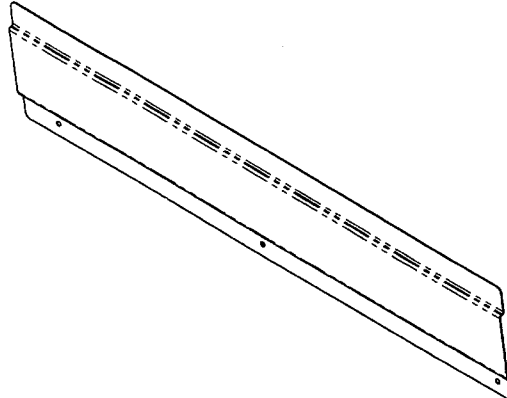
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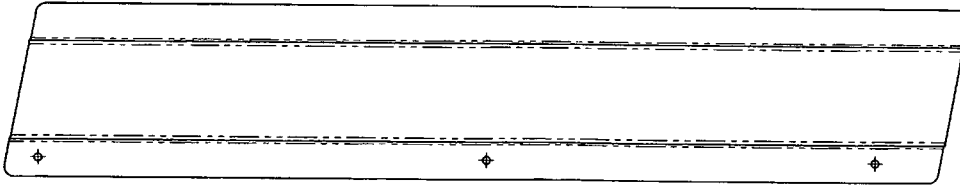
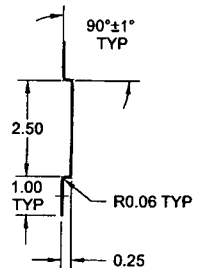
8 7 6 5 4 3 2 1



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
(MAKE FROM D3641-3F FLAT PATTERN) $\triangle C$



D3641-3 COVER (SHOWN)
D3641-4 COVER (OPPOSITE)



D3641-4 COVER
(REPLACES GENEVA P/N G10606-4)
(MAKE FROM D3641-3F FLAT PATTERN) $\triangle C$

w/o 38833

RELEASED
2009-11-10
MD

NOTES:

- 1) MATERIAL: D3641-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3641	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER	NTS
DATE	09.10.02	<small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND TO BE SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COVER OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

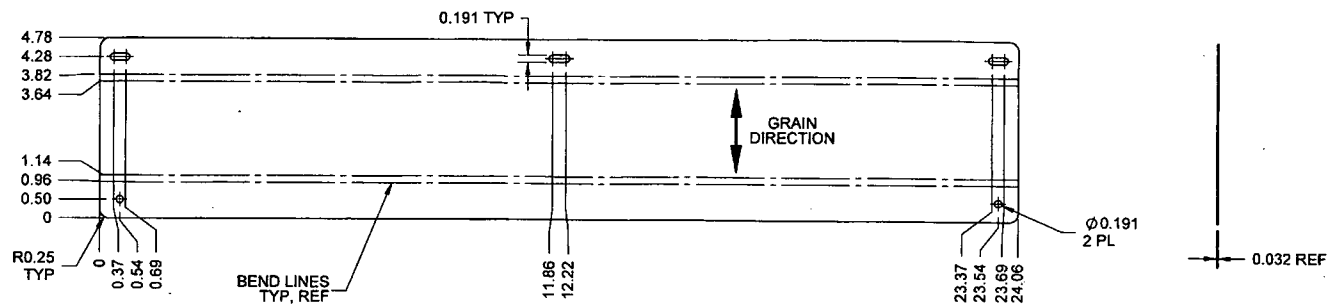
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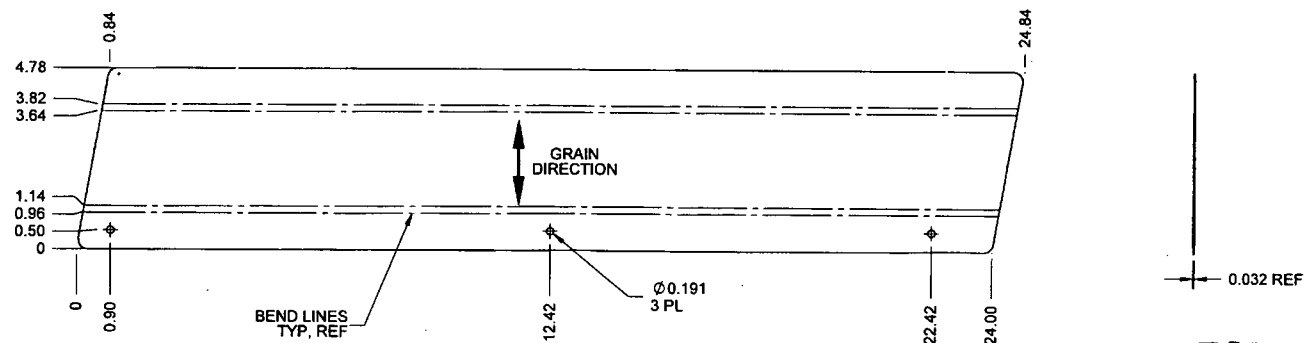
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NOTE: Date & initial all entries



D3641-1F FLAT PATTERN



D3641-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 OR ASTM B209
REF DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1F/-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3641	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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W/O 58833

RELEASED
2009-11-10

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